

Work Order ID 144081

April 01, 2016 11:02:57 AM

144081

Page 1

Item ID: D3197-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 4/20/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 4/29/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: SW Date: 16040 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3197	Rev B								

100	*100*	BAND SAW	0.00						
	Bandsaw	Memo	0.00						
	Jeaspa Bandsaw	Cut blanks: 29.125" long							
110	*110*	HAAS CNC VERTICAL MACHINING #1	0.00						
	HAAS 1	Memo	0.10						
	HAAS CNC vertical machine #1	1-Face ends to lenght per dwg D31972-Machine D3197-1 as per Folio FA340 and Dwg D31973-Deburr							
120	*120*	QC2- Inspect parts off machine FAI/FAIB	0.00						
	QC	Memo	0.00						
	Quality Control								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
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130 *130* Lathe Conv Conventional Lathe	CONVENTIONAL LATHE Memo Chamfer as per Dwg D3197	0.00 0.00		16	04/23	10	0		DAS 08 9-80
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				10			SL 16/4/24
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.02				10	0		SL 16/4/25

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160 *160* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3 <i>m 130746</i> Memo START TIME: <i>11:45</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>12:15</i>	0.00 0.01				<i>10</i>	<i>0</i>	<i>16-04-25</i>	<i>DAS 34 9:28</i>
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>(10)</i>			<i>DAS 38 9:28</i> APR 25 2016
180 *180* Small Fab Small Fab	Small Fab Memo Assemble D3197-041 as per Dwg D3197	0.00 0.05				<i>10</i>	<i>FF</i>	APR 26 2016	

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190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>10</u>			DAS 38 9-89 APR 29 2016
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>Steps</u> Memo	0.00 0.00				<u>10</u>		DAS 8 9-89	APR 29 2016
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.02				<u>MCJ</u>			MAY 02 2016 MCJ MAY 02 2016

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☐ OTHER : _____					

Picklist Print

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144081

Parent Item: D3197-041

D3197-041

Parent Item Name: Bar

Start Date: 4/20/2016

Required Date: 4/29/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: A New Issue 05-11-08 JLM
IPP Rev: B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS27039-1-24		Purchased	No			100	Each	21.0000	2	20			
MS27039-1-24									**		FF	APR 26 2016	
Screw													

Location	Loc Qty	Loc Code
GA 1284537	3	
m127432	3	
ST279 11134537	18	
m127432	18	

D2690-5		Manufactured	No			180	Each	19.0000	2	20			
D2690-5									**		FF	APR 26 2016	
Lanyard Assembly													

Location	Loc Qty	Loc Code
ST009 144095	19	
136050	19	

D3242-1		Manufactured	No			180	Each	19.0000	2	20			
D3242-1									**		FF	APR 26 2016	
Tag													

Location	Loc Qty	Loc Code
GA 144 B144096	19	
135074	9	
140760	10	

20

Picklist Print

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Parent Item: D3197-041

D3197-041

Parent Item Name: Bar

Start Date: 4/20/2016

Required Date: 4/29/2016

Start Qty: 10.00

Required Qty: 10.00

D3489-3-200

Manufactured No

180

Each

6.0000

2

20

D3489-3-200

Pip Pin

FF

APR 26 2016

Location 144 157

Loc Qty

Loc Code

GA 143844

6

140485

4

140755

2

18

2

M7075T73R1.000

Purchased No

180

f

9.5730

2.42

30.25

M7075T73R1 000

7075-T73 Rd Bar 1.00

16/04/22

Location

Loc Qty

Loc Code

MAT

9.573

m133054

9.573

9.573

MS21042L3

Purchased No

180

Each

2,202.000

2

20

MS21042L3

Nut

19.275'

FF

APR 26 2016

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

808

m133790

8

m134360

800

20

Return2016

1

M132382

1

ST304

1293

m134039

126

m134360

1167

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Shop Packet Print

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Picklist Print

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Start Date: 4/20/2016

Required Date: 4/29/2016

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0363J

Purchased

No

180

Each

1,358.000

6

60

NAS1149D0363.J

FF

APR 26 2016

Washer

Location

Loc Qty

Loc Code

GA

628

m134055

628

Return2016

2

m132317

2

ST263

728

m134370

728

60

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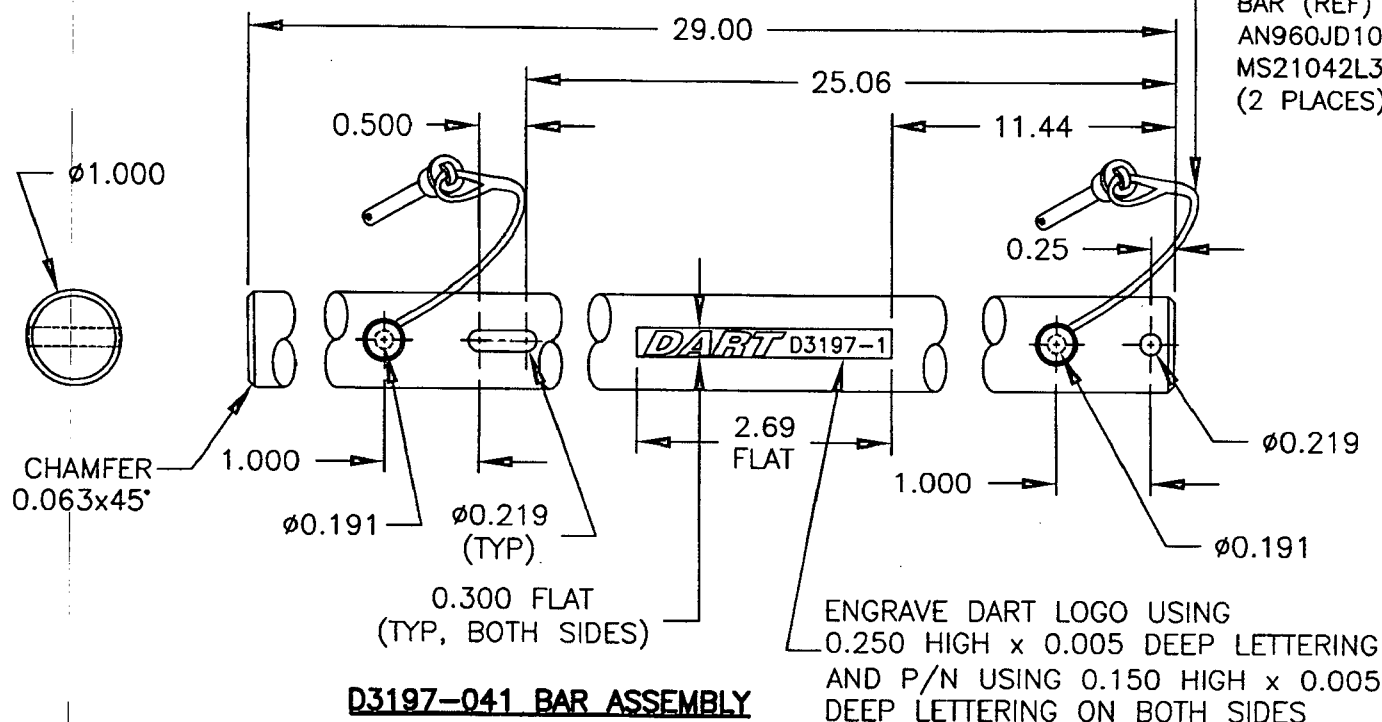
Shop Packet Print

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RELEASED

DART

- D3489-3-200 PIP PIN (1)
- D3242-1 TAG (1)
- MS27039-1-24 BOLT (1)
- AN960JD10 WASHER (1)
- D2690-5 LANYARD (1)
- AN960JD10 WASHER (1)
- BAR (REF)
- AN960JD10 WASHER (1)
- MS21042L3 NUT (1)
- (2 PLACES)



D3197-041 BAR ASSEMBLY

D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) ϕ 1.000 O.D. (REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER END OF THE BAR

20160401

SLA 144081

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.10	TITLE	D3197	REV. B
		BAR		SHEET 1 OF 1
		NEW ISSUE		SCALE 1:1
		CHG PIP PIN; ADD D3242-1 TAG		

